

**Work Order ID 54709**

December 16, 2009 3:28:07 PM



Page 1

Item ID: D2324-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 16/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 09/12/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2324	Rev C								
100	BAND SAW	0.00							
	Memo	0.00							
Bandsaw	Cut blanks: (0.75" x 0.75") x 5.75" Long Bar								
Jeaspa Bandsaw									

09/09/10 12 - 0

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	Memo	0.00							
HAAS 1	1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges. Identify as D2324-3								
HAAS CNC vertical machine #1									

09/09/10 12 - 0

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									

09/09/10 12 - 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

**Work Order ID 54709**

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Start Date: 16/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

  
H.A 09/12/20

12

Ø

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 54709**

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Item ID: D2324-3

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Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 16/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Identify as per dwg &amp; Stock Location:

0.00

100

9/12/22

(12) f

Packaging

Packaging

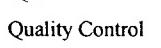
170



QC21- Final Inspection - Work Order Release

0.00

QC



Memo

0.00

Quality Control

09/12/22 JF

C209/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

December 16, 2009 3:28:11 PM

Work Order ID: 54709



Parent Item: D2324-3



Parent Item Name: Bar

Start Date: 16/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch.	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X00.750		Purchased	No			100	f	38.0358	6.6947			

6061-T6 Bar .750 x .750



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	38.03582632	
107387	2.49	
108877	3.3453	
112567	32.2005263	

6.6947 on 09/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

DART AEROSPACE LTD	Work Order:	54109
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Measured by:	<i>AmR</i>	Audited by:	<i>B. A</i>	Prototype Approval:	N/A
Date:	09/12/19	Date:	09/12/20	Date:	N/A

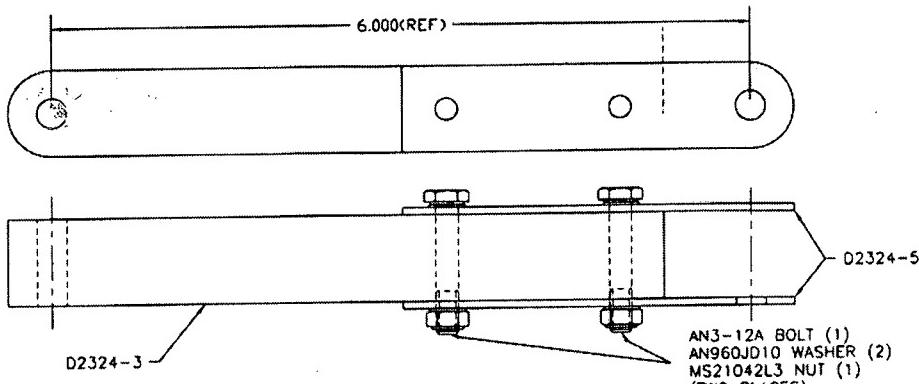
Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue P/O D2324-1	KJ/JLM	JL
B	06.03.08	Dwg Rev changed	KJ/JLM	JL

**DART**

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14	TITLE STRUT	SCALE	

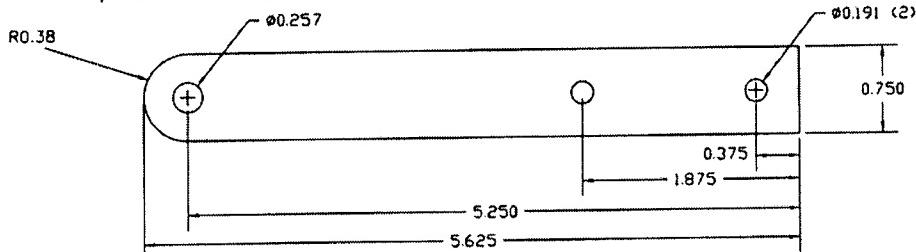
  

RELEASED 04.12.16 <i>[initials]</i>	A	94.11.08	NEW ISSUE
	B	96.05.07	UPDATE MATERIALS
	C	04.12.14	UPDATE NOTES



**D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (00-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**SHOP COPY**

RETURN TO:

ENGINEERING

**UNCONTROLLED COPY**

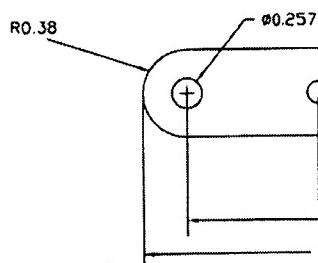
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 34709

*By 09/12/16*



**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED